

# Work Order ID 66224

February 8, 2011 8:00:07 AM



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Item ID:	D4185-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Internal Bellcrank Assembly					
Start Date:	2/11/11	Start Qty:	2.00	Cust Item ID:		
Required Date:	2/25/11	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/02/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4185	<u>PA1</u>	<u>11.03.03</u>							

100	<u>PA1</u>	<u>11.03.03</u>	0.00						
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Large Fab			0.00						
Large Fab	Memo								

1-Weld as per DWG D4185 USING ALIGNMENT FIXTURE DT 9719  
 \*\*\*\*\*brush weld right after welding, to take color off \*\*\*\*\*  
 A/RER316L SS Filling Rod M114509

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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QC	Memo	0.00							
Quality Control									

140	Identify as per dwg & Stock Location: <u>Perk</u>	0.00							
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Packaging	Memo	0.00							
Packaging									



PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Item ID: D4185-041 Accept  Setup Start   
Revision ID: PRELIM Stop   
Item Name: Internal Bellcrank Assembly  
Start Date: 2/11/11 Start Qty: 2.00  Cust Item ID:  
Required Date: 2/25/11 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

RD 2334  
PL 11-06-9  
②

POSITIVE RECALL  
EFFECTIVE 11/2/08 AUTH 11  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Picklist Print

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**Work Order ID:** 66224

**Parent Item:** D4185-041

**Parent Item Name:** Internal Bellcrank Assembly

**Start Date:** 2/11/11

**Required Date:** 2/25/11

**Start Qty: 2.00**

**Required Qty: 2.00**

**Comments:** IPP REV:A 10.12.13 NEW ISSUE DD VERF:JLM  
IPP REV:B 11-02-03 REVISED TO PA5 JLM VERIFIED BY:DD

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

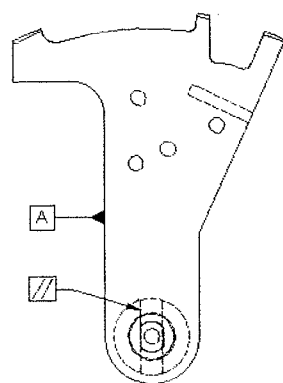
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

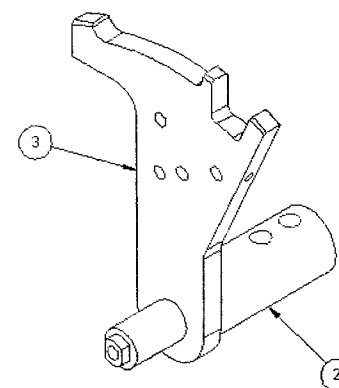
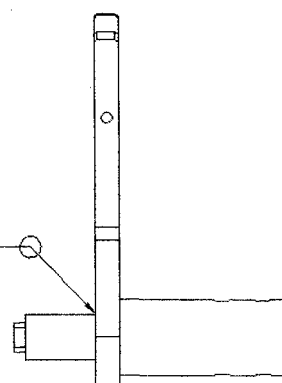
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D4185-041	INTERNAL BELLCRANK ASSEMBLY
2	1	D4185-15	SHAFT
3	1	D4185-1	PLATE



0.125 MAX



# D4185-041 INTERNAL BELLCRANK ASSEMBLY

**PRELIMINARY ISSUE**

10.11.12

## NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

PA7	NEW ISSUE		10.11.12
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4185	SHEET 1 OF 9
APPROVED		TITLE	SCALE
DE APPR.		INTERNAL BELLCRANK	NTS
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